

Work Order ID '77560

December-13-11 1:49:26 PM

77560

Page 1

Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad
 Start Date: 13/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr
304, 363 if necessary

B1-12-20

(60)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B1-12-20

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

501(2)21

counted
(x60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					(60)			
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1								
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 2059B Hardcoat M1200165 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary								
150		0.00							
150	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									

SB 11/12/22

X/60 12-01-19 JBL

Count (460)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 1:40 OVEN TEMPERATURE:								
	FINISH TIME: 32:00F 2:10								
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

60x4 m/12/01/24

60x 4 m 12/01/24

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location:	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

60x48mm/12/01/24

12/1/25

2012-01-24
(40)

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77560

77560

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	150.8300	0.106	4.463158	6.5		
M304S16GA									**		IBI-12-20		
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

150.83

119653

150.83

119653

(60)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77560
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.254	2		HB-03	Ver
3.500	+/-0.010	3.500	2		"	
1.965	+/-0.010	1.973	2		"	
2.795	+/-0.010	2.798	2		"	
3.625	+/-0.010	3.626	2		"	
0.220 x 0.380	+/-0.010	0.220 x 0.378	2		"	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-12-20	Date: 11/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

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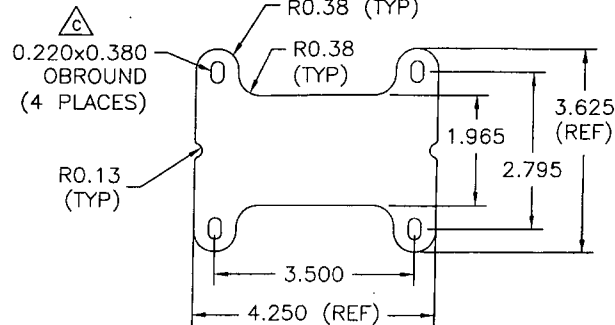
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

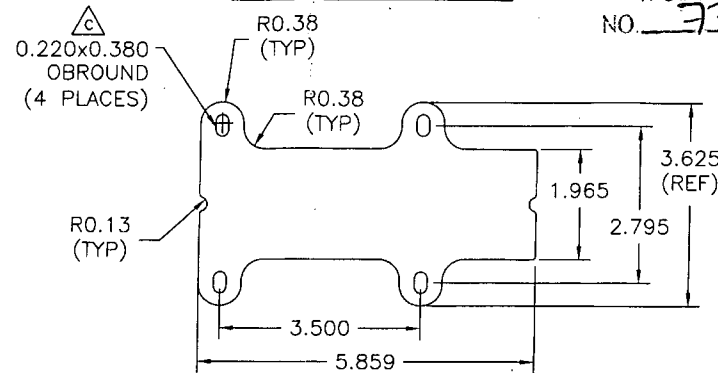
NO. 77560 M.C.J

111213

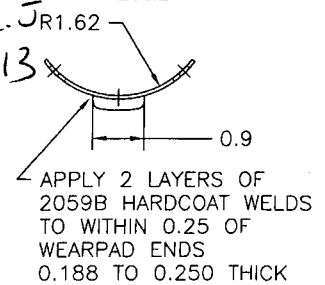
D3537-1F FLAT PATTERN



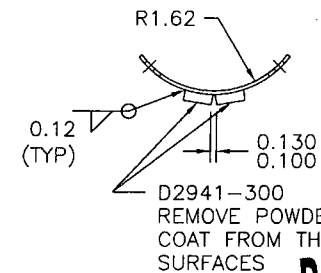
D3537-3F FLAT PATTERN



SECTION A-A

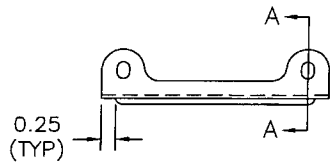


SECTION B-B

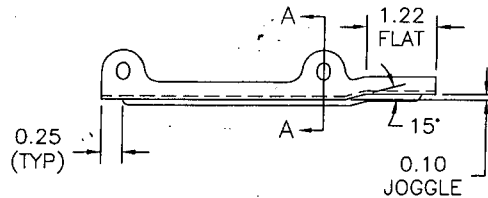


UNDER REVIEW
11/10/13
OK 11/11/13

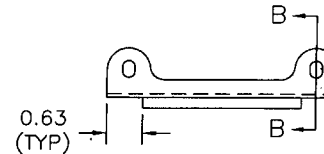
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



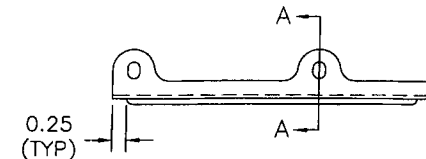
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07-05-08 AH
per ELM
962

D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

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